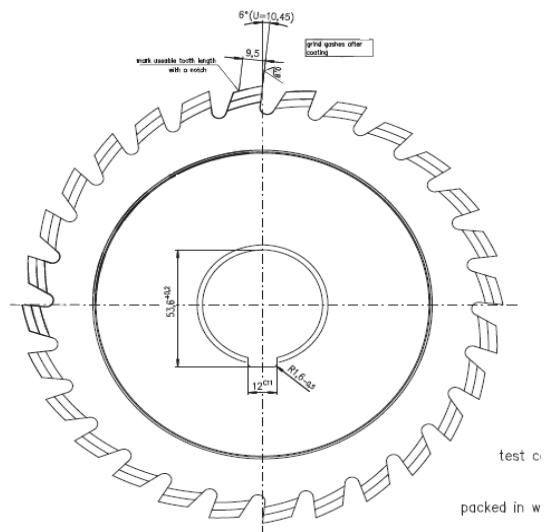


Rack Milling Cutter Ø200 Z28

A12-020

Resharpening cycles for helical rack milling cutters with tapered wheel: 1 pass pregrinding, 4 passes finishing with increments of 0.01 mm, 2 passes sparkout with below mentioned feeds for a total materialremoval of 0.2 mm.



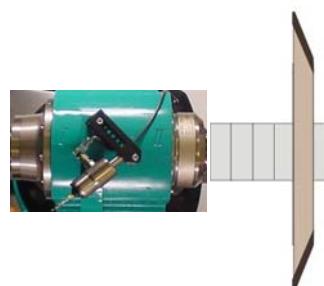
1. Cycletime for Resharpening

Workpiece: Ø 200 mm, Z 28, Length 168 mm, Helix 10°, RA 6° Material HSS			
Operations	Probe	Flute pregr.	Flute fin.
Feed [mm/Min]	2000	150	400
Power [kW]		3	2
Cutting feed [m/s]		32	32
Used wheels		1	1
Grinding time [s]	6	2088	1717
Total cycle time	92 Min 9		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 1V1 Ø125 B106 20°



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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Dresser, Tailstock

Responsible engineer: OP, 30.6.2011

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